

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 481512/481513 STAINLESS STEEL SIDE ENTRY STEPS ON:  
2500/3500 SERIES CHEVROLET AND GMC EXTENDED & CREW CAB PICKUPS



1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL REQUIRED PARTS (LISTED ON SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. PREASSEMBLE THE FRONT LEFT HAND BRACKETS (ITEMS #12, 14) AS SHOWN IN **FIG. 1** USING (3) 3/8-16 X 1.0 SCREW, 3/8" FLAT WASHERS AND 3/8" FLANGE NUT. (ITEM #21, 22, 24).  
**NOTE: IF YOU ARE MOUNTING THE STEPS ON A 1500 MODEL PICKUP, YOU MUST ATTACH THE SMALL 90 DEG. BRACKET (ITEM #25) TO THE FRONT BRACKETS (SEE FIG 1). REPEAT FOR FRONT RIGHT HAND BRACKETS. TORQUE TO 19 LB. FT.**
3. ASSEMBLE THE LOAD REACTION STUDS AND HARDWARE (ITEM #20 THRU #23) AS FOLLOWS.
  - 3.1. ON THE SHORT THREADED END OF THE LOAD REACTION STUD (ITEM #23), INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #22) BACKWARDS TO THE BOTTTOM OF THE THREAD. THEN INSTALL A 3/8" FLAT WASHER (ITEM #21) AND RUBBER "CUSHION" WASHER (ITEM # 20) TIGHT UP AGAINST THE SERRATED FLANGE NUT. (THE END OF THE STUD MUST BE RECESSED IN THE RUBBER WASHER APPROX. 3/16").
  - 3.2. ON THE LONG THREADED END OF THE STUD, INSTALL A 3/8" SERRATED FLANGE NUT (ITEM # 22) BACKWARDS TO NEAR TO THE BOTTTOM OF THE THREADS
4. ATTACH THE LOAD REACTION STUD ASSEMBLIES TO THE MOUNTING BRACKETS AS SHOWN. INSERT THE STUD, FROM WHAT WILL BE IN THE INBOARD OR FRAME SIDE THRU THE LOWEST HOLE IN THE BENT FLANGE OF THE BRACKET THAT WILL ALLOW THE RUBBER WASHER TO SEAT FIRM AGAINST THE SIDE WALL OF THE FRAME. INSTALL A BLACK FLANGE NUT (ITEM #22) ON THE OUTBOARD END OF THE STUD (FINGER TIGHT ONLY).

### NOTE:

**DUE TO EXCESSIVE THREAD LOCKER IN THE BODY MOUNT BOLT AREA ON THE 2010+ GM SILVERADO/SIERRA, USE CAUTION WHEN REMOVING THE BODY MOUNT BOLTS.**

5. REMOVE THE FACTORY FRONT, CENTER, AND REAR BODY MOUNT BOLTS (ONE SIDE OF THE VEHICLE AT A TIME) AND INSTALL THE MOUNTING BRACKETS PER THE FOLLOWING INSTRUCTIONS:
  - 5.1. INSTALL THE FRONT MOUNTING BRKT (ITEM #14) TO THE FRONT BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
  - 5.2. INSTALL THE CENTER MOUNTING BRKT (ITEM #15 & #16) TO THE CENTER BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
  - 5.3. INSTALL THE REAR MOUNTING BRKT (ITEM #19) & WASHER (ITEM #26) TO THE REAR BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
  - 5.4. ATTACH THE REAR OUTBOARD MTG BRKT (ITEM #17 & #18) TO THE REAR INBOARD MTG BRKT (ITEM #19), USING (3) 3/8-16 X 1.0 SCREW, 3/8" FLAT WASHERS AND 3/8" FLANGE NUT. (ITEM #21, 22, 24). THE REAR OUTBOARD MTG BRKT MUST BE MOUNTED TO THE BACK SIDE OF THE REAR INBOARD MTG BRKT (TOWARDS THE REAR OF THE VEHICLE) AS SHOWN IN FIG 2 AND 3. BE SURE TO USE THE CORRECT HOLES AS SHOWN IN FIG. 2 & 3. NOTE THAT THERE IS A DIFFERENCE BETWEEN THE DOUBLE CAB AND CREW CAB APPLICATIONS. TORQUE THE BOLTS TO 19 LB. FT.



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6. ATTACH THE STEP PLATE ASSYS (ITEM #1 THRU #9) TO THE MTG BRKTS. USE #10-24 X 3/4 CARRIAGE BOLT (ITEM #10) & #10-24 SERRATED FLANGE NUT (ITEM #11). (TORQUE THESE FASTENERS TO 6 LB. IN.) **(NOTE: INSURE THAT THE MOUNTING BRACKETS DO NOT TOUCH THE INSIDE WALL OF THE BODY MOUNT HOUSING AND TORQUE THE BODY MOUNT FASTENERS TO MANUFACTURES SPECS) .**
7. POSITION THE STUD ASSY SO THAT THE RUBBER CUSHION IS SNUG UP AGAINST THE SIDE OF THE FRAME. TIGHTEN THE 3/8" FLANGE NUTS ON EITHER SIDE OF THE BRKT TO 19LB. FT.

## SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	551842	1	STEP PLATE -RH, CHEVY/GMC 2500/3500, DOUBLE CAB
1	551844	1	STEP PLATE -RH, CHEVY/GMC 2500/3500, CREW CAB
2	551843	1	STEP PLATE -LH, CHEVY/GMC 2500/3500, DOUBLE CAB
2	551845	1	STEP PLATE -LH, CHEVY/GMC 2500/3500, CREW CAB
3	104250	2	END CAP-RH FRONT/LH REAR
4	104251	2	END CAP-LH FRONT/RH REAR
5	105500	4	PAD-MLD,STEP PLATE,20.00 X 5.50
6	104255	2	TRIM-SEAL,SES,EXTD,80.5", EXT CAB
6	102502	2	TRIM-SEAL,SES,EXTD,95", CREW CAB
7	104257	12	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
8	107645	4	CLIP-U, .115-.185, BLK
9	107958	4	SCR-PPH, #8-18 X 1/2, SST
10	104258	12	BOLT, ROUND HEAD, SST, #10-24 X 3/4"
11	104261	12	NUT, SERR FLG, HEX, SST, #10-24
12	551814	1	BRACKET-MTG, FRONT, LH, 481512/481513
13	551817	1	BRACKET-MTG, FRONT, RH, 481512/481513
14	551817	2	BRACKET-MTG, FRONT, INBOARD, 481512/481513
15	551815	1	BRACKET-MTG, CENTER, LH, 481112/481113
16	551818	1	BRACKET-MTG, CENTER, RH, 481112/481113
17	551816	1	BRACKET-MTG, REAR, OUTBOARD, LH, 481112/481113
18	551819	1	BRACKET-MTG, REAR, OUTBOARD, RH, 481112/481113
19	551826	2	BRACKET-MTG, REAR, INBOARD, LH/RH, 481112/481113
20	102592	6	WSHR, RUBBER, .354 ID X 1.00 OD X .75 THK
21	100062	18	WSHR, FL, 3/8", .438 ID X 1.00 OD X .083" THK
22	100181	30	NUT, SERR FLG, HEX, 3/8-16 UNC, ZP
23	104686	6	STUD, -DBL ENDED, STL, 3/8-16 X 4.00", ZP
24	100040	12	SCR-HEX HD, 3/8-16 UNC, ZP
25	551571	2	BRACKET-90 DEGREE, 3 HOLE
26	108882	2	WSHR, FL, .59 ID X 1.06 OD X .19 THK, ZP



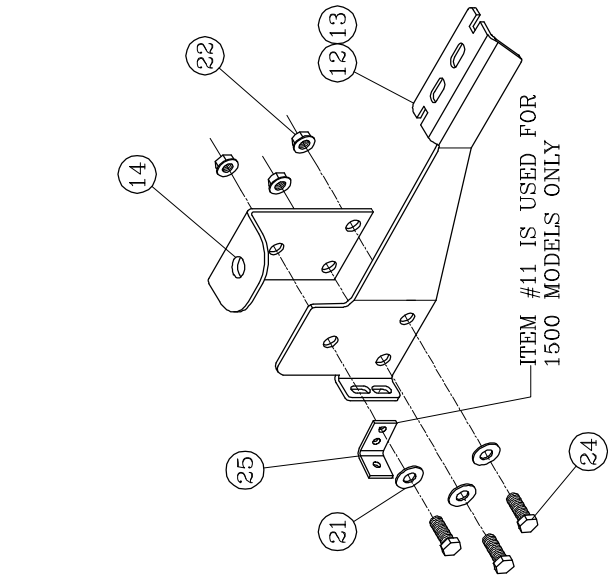
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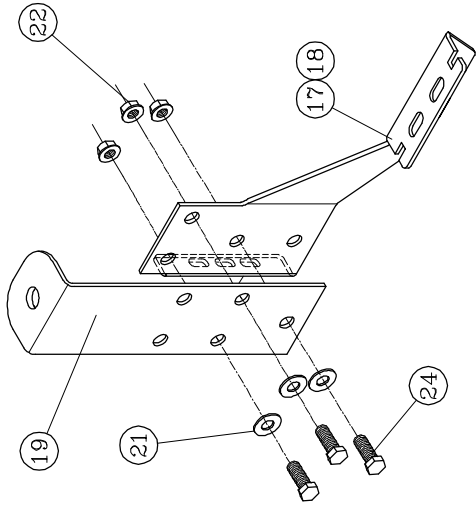
SERVICE PARTS LIST

MODEL NO. 481512/481513

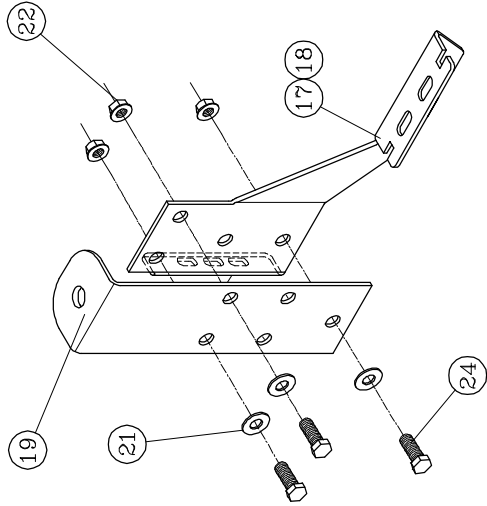


FRONT BRACKET ASSEMBLY

FIG. 1



DOUBLE CAB REAR BRACKET ASSEMBLY



CREW CAB REAR BRACKET ASSEMBLY

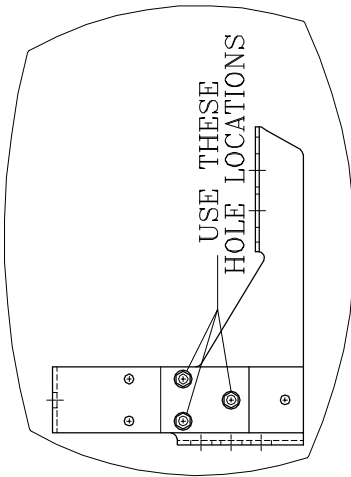


FIG. 2

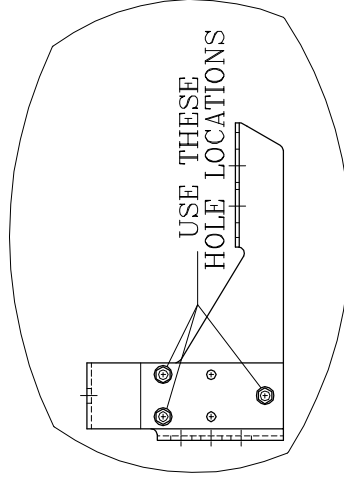
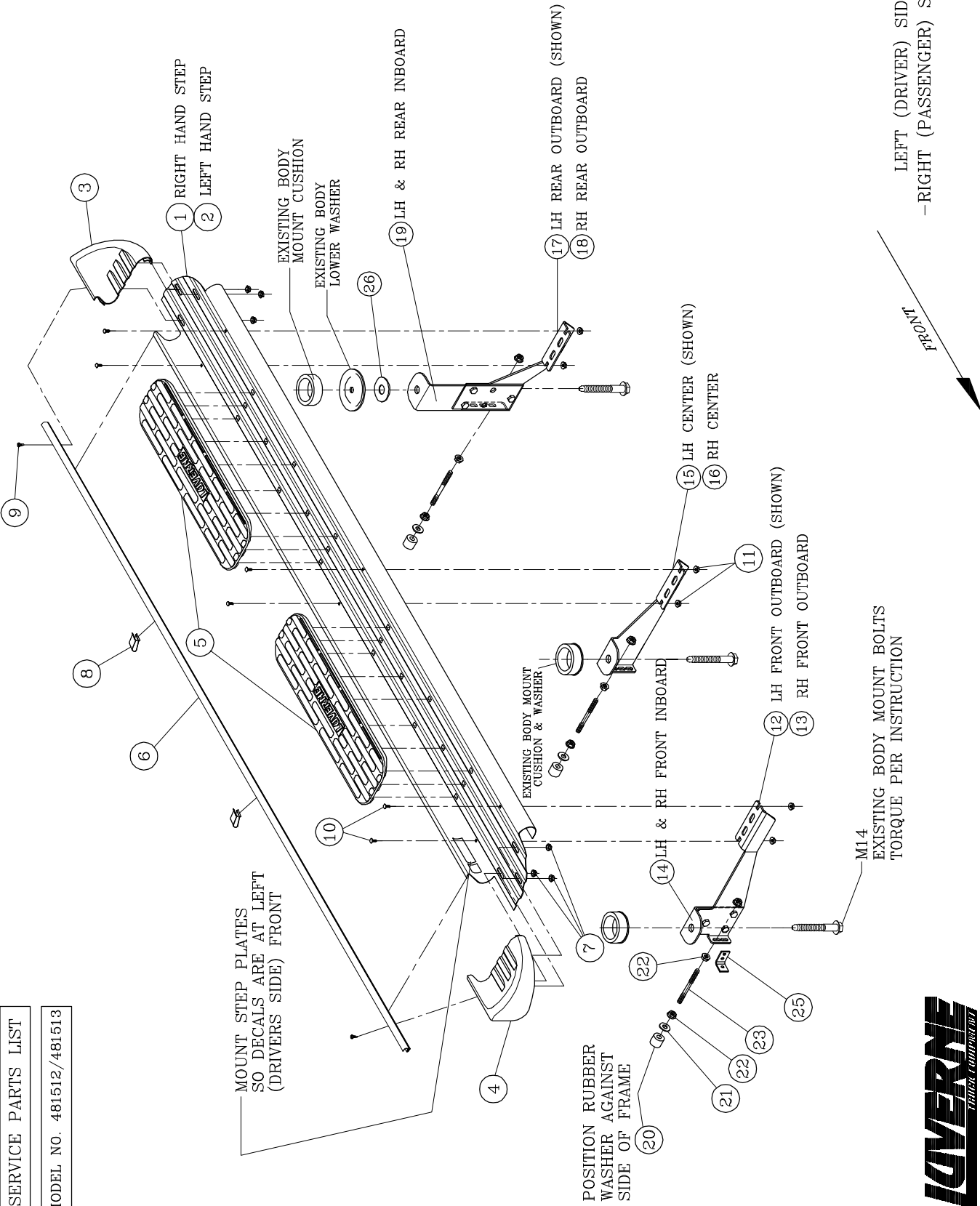


FIG. 3



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FIG. 4



LEFT (DRIVER) SIDE SHOWN  
-RIGHT (PASSENGER) SIDE OPPOSITE-

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